

RG 104, 8NS-104-94-077
Box 6

8NS-104-94-077, Miscellaneous
Correspondence & Memos, 1897-1994

Notes on Panamanian Currency

1 - Babboa

Panama.

dia
1495

wt - 412.5

5 - Babboa

1,517 $\pm$.003

.114 $\pm$.0015

.539 grs

.1155

\$1 - Rolling Schedule -

To: Superintendent's of Melting, Coining Assay,
Cash and Mechanical Divisions

From: Cost Accounting Branch

Subject: Job Numbers for 1 Balboa, Panama
Coins

<u>Melting</u>	<u>Dept.</u> 7700	<u>Charge</u> 7790	<u>Denominations</u> Per 100
<u>Process Weigh</u>	8100	8190	1 Balboa
<u>Rolling</u>	7900	7990	1 Balboa
<u>Blanking</u>	8200	8290	1 Balboa
<u>Annealing</u>	8300	8390	1 Balboa
<u>Upsetting</u>	8500	8590	1 Balboa

Selecting	Dept	Change	
	8500	8890	1 Barrel

Stamping	8600	8690	1 Barrel
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Counting	8700	8790	1 Barrel
Stores House - Bag-		8790	1 Barrel

Material Handling	7800	7890 - 2	Trucks
		7890 - 3	Ships
		7890 - 4	1 Barrel Dump

Assay Division	3500	7790	
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Mechanical Division	Dept		
	6000		

6010	Collar
8274	Sharpening Dies etc
8574	Segmented Discs
8674	Sharpening Dies



OFFICE OF
DIRECTOR OF THE MINT

THE DEPARTMENT OF THE TREASURY

WASHINGTON, D.C. 20220

AUG 7 1975

RECEIVED
AUG 11 1975
OFFICE OF
SUPERINTENDENT
U. S. MINT AT DENVER

Superintendent, U. S. Mint, Philadelphia, Pa. 19106
Superintendent, U. S. Mint, Denver, Colo. 80204

We have firm plans to manufacture 19,200,000 coins of six denominations, dated 1975, for the Government of Panama. Production is assigned to the field offices in quantities indicated as follows:

Denomination	Quantity	Office
1 Centesimo	10,000,000	Philadelphia Mint
2 1/2 Centesimos	1,000,000	Philadelphia Mint
5 Centesimos	5,000,000	Denver Mint
1/10 Balboa	500,000	Denver Mint
1/4 Balboa	1,500,000	Denver Mint
1/2 Balboa	1,200,000	Denver Mint
	19,200,000	8.2 million

The responsibilities of each office in this program are as follows:

PHILADELPHIA MINT

Change date on hubs to 1975 and trial strike each denomination.

Specifications - Finished Coins

Denomination	Alloy	Weight (grams)	Diameter (mm)
1 Centesimo	95 Cu/5 Zn	3.11	19.05
2 1/2 Centesimos	91.67 Cu/8.33 Ni Clad	1.631	15.00
5 Centesimos	75 Cu/25 Ni	5.00	21.21
1/10 Balboa	91.67 Cu/8.33 Ni Clad	2.27	17.91
1/4 Balboa	91.67 Cu/8.33 Ni Clad	5.67	24.26
1/2 Balboa	91.67 Cu/8.33 Ni Clad	11.34	30.61

orig. Planning Div.
copy: Acct. Div.
Cash. Div.
Bldg. & Mech. Div.



Keep Freedom in Your Future With U.S. Savings Bonds

Tolerances: Diameter $\pm 0.076\text{mm}$; Thickness $+ 0.127\text{mm} - 0.076\text{mm}$; Weight $\pm 4.0\%$. The 1, 2 1/2, and 5 Centesimos have plain edges; the 1/10, 1/4, and 1/2 Balboas have reeded edges.

1. Trial Strikes

Our standard blanks for U.S. coins will be used for all denominations except the 2 1/2 Centesimo coin. Specifications on the 2 1/2 Centesimo blank (established at the 11/26/73 trial strike procedure) are as follows:

	<u>Cut Blank</u>	<u>Upset Blank</u>
Diameter	0.592"	0.586"
Thickness	0.042"	0.047"

Trials for this program are tentatively scheduled for August 11, 1975. It is anticipated existing tooling from our prior 2 1/2 Centesimo program conducted at the Philadelphia Mint is on hand to provide the set-up pieces needed for trial strikes, and for the trial specimens (2 of each denomination) to be furnished Public Services for obtaining approval by the Panamanian Embassy.

2. Manufacture: 1 Centesimo - 10,000,000 (use U.S. 1-cent blanks)
2 1/2 Centesimo - 1,000,000 (use U.S. 10-cent gage coinage material)

3. Collars and Dies

*Collars for all coins except the 2 1/2 Centesimo are on hand. Additional 2 1/2 Centesimo collars must be fabricated for use by the Philadelphia Mint, if required.

*Working dies are to be manufactured after approval of trials by Panama. Shipment to be made as soon as practical after receipt of orders from the Denver and Philadelphia Mints.

4. Coin Bags - Manufacture, label, and upon receipt of order ship coin bags as follows:

Denomination	Bag Markings		Bags Required	Mint Required
	No. of Coins	Value		
1 Centesimo	5,000	B/50.00	2,000	Philadelphia
2 1/2 Centesimo	10,000	B/250.00	100	Philadelphia
5 Centesimo	4,000	B/200.00	1,250	Denver
1/10 Balboa	10,000	B/1000.00	50	Denver
1/4 Balboa	4,000	B/1000.00	375	Denver
1/2 Balboa	2,000	B/1000.00	600	Denver
			<u>4,375</u>	

5. Boxes - Provide boxes for the one and 2 1/2 Centesimo coins (only), as follows:

Denomination	Coins Per Bag	Bags Per Box	Total Bags	Total Boxes
1 Centesimo	5,000	2	2,000	1,000
2 1/2 Centesimo	10,000	2	100	50
			2,100	1,050

Boxes are to be marked with:

- Denomination
- Box Number - 1 Centesimo 1 to 1,000
2 1/2 Centesimo 1,001 to 1,050
- "Panama - Hacienda Y Tesoro"

Boxes are to be nailed and banded with 2 steel bands then secured on skids.

Proceed with bag, box, and skid fabrication immediately, and also any tooling required.

DENVER MINT

1. Manufacture:
- 5 Centesimo - 5,000,000
 - 1/10 Balboa - 500,000
 - 1/4 Balboa - 1,500,000
 - 1/2 Balboa - 1,200,000

Since weight, size, and alloy specifications and edge detail specifications are identical to U.S. coins, our standard U.S. blanks, collars, and feeder tooling will be used on this program.

2. Packaging of Coins -

Denomination	Coins Per Bag	Bags Per Box	Total Bags	Total Boxes
5 Centesimos	4,000	2	1,250	625
1/10 Balboa	10,000	2	50	25
1/4 Balboa	4,000	2	375	188
1/2 Balboa	2,000	2	600	300
			2,275	1,138

→ Le Ray: will our standard U.S. bags do for this
* can we label them as indicated above?

WHD

*The boxes will be marked with:

a. Denomination

b. Numbered as follows:

5 Centesimos	1,051 - 1,675
1/10 Balboa	1,676 - 1,700
1/4 Balboa	1,701 - 1,888
1/2 Balboa	1,889 - 2,188

c. "Panama - Hacienda Y Tesoro"

*Each box will be nailed, banded with 2 steel straps, and secured on skids.

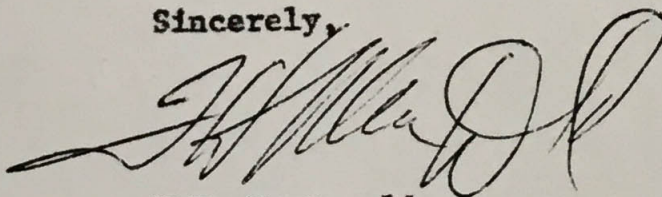
*Proceed with the ordering of dies, bags, boxes, and skids.

PHILADELPHIA AND DENVER MINTS

Production will commence as soon as possible after approval of the trial strikes. Panama has indicated an urgent need for these coins, and we have agreed to attempt completion of the program, including boxing and skidding, by October 11, 1975.

Our costs were quoted CIF Panama. We will furnish each office with the name of their respective carrier as soon as same becomes available.

Sincerely,



F.H. MacDonald
Acting Director of the Mint

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendent's of Melting, Coining, Assay,
and Mechanical Divisions

DATE: October 4, 1971

FROM : Cost Accounting Branch

SUBJECT: Job Number Panama 5 Balboa Blanks

Melting

Dept.

Charge

Denomination

7700

7761

Ingot

Process-Weighing

8100

8161

✓ Rolling (Includes Slab Annealing)

7900

7961

✓ Blanking

8200

8261

Counting

8700

8761

Stores Items

Bags

8700

8761

Boxes

8762

Assay

3500

7761 Ingot

Mechanical

6000

8261 5 Balboa Die Sets

8561 5 Balboa Discs & Segments



40 lbs needed

500 Blanks

5 Balboa for Panama.

Diameter = $1.517 \pm .003$

Thickness = $.114 \pm .0015$

~~WT = 35 Grams~~

WT = 539 Grams

Rolling 7961

Blanking 8261

12.98 Pieces/lb

Produced 9/14/71

3,551 lbs

45,633 Pieces

15.4 Grams to one Gram.

act. # no

Oct. 4, 1971

7-20-72

539 grs

1.51⁸~~7~~ dia

.115 to .116 = $\pm$ 5 grs

.114 = 10 grs LITE

Final 5 Balboa Panama.

Rec @ .225

Dial Gauge

235 190 Void

195 150 155

~~120~~ ~~amended~~ X Ray.

180.	175	135	
	115	125	- 678
175.		118	- 644
170.		114	626
175.			

1-BALBOH.

10-18-72

REC @ 220

90-10 SILVER

PASS

DIAL

GAUGE

X-RAY

1

235

.190

ANNEAL.

2

185

.135

3

170

.115

4

160

.102

5

160

.096

SELECT 5

6

155

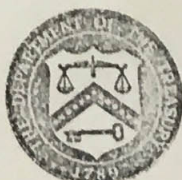
.089

515-1

EDGE-.0885 CENTER-.0895

DIA, 1.495

WT-412.5



OFFICE OF
DIRECTOR OF THE MINT

THE DEPARTMENT OF THE TREASURY

WASHINGTON, D.C. 20220

AUG 7 1975

Tenorio
RECEIVED
AUG 11 1975
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Superintendent, U. S. Mint, Philadelphia, Pa. 19106
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DENVER MINT

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- | | |
|-------------|-------------|
| 5 Centesimo | - 5,000,000 |
| 1/10 Balboa | - 500,000 |
| 1/4 Balboa | - 1,500,000 |
| 1/2 Balboa | - 1,200,000 |

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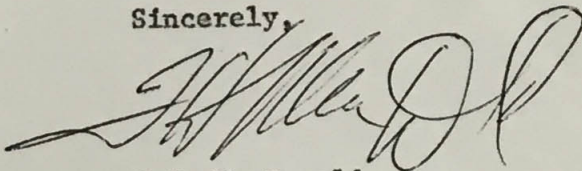
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Sincerely,



F.H. MacDonald

Acting Director of the Mint

R+C

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendents - Coining, Cash & Deposits,
Mechanical and Assay Divisions

DATE: November 19, 1968

FROM : Cost Accounting Section

SUBJECT: Panama - Strips and Blanks Processed to One Cent and Five Cent Coins

Process Weighing

Dept.

Charge

8100

8173

One Cent

8174

Five Cent

Rolling

Dept.

8200

8273

One Cent

8274

Five Cent

Handling Strip

8279

One Cent

Blanks - Handling

8280

Five Cent

Annealing

Dept.

8300

8373

One Cent

8374

Five Cent

Upsetting

Dept.

8500

8573

One Cent

8374

Five Cent

Selecting

Dept.

8800

8873

One Cent

8874

Five Cent

Stamping

Dept.

8600

8673

One Cent

8674

Five Cent

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan



MEMORANDUM (CONTINUED)

SUBJECT: Panama - Strips and Blanks Processed to One Cent and Five Cent Coins

Counting

Dept.

8700

Charge

9800 Supervision
9801 Indirect
9873 - 1¢ Bags, Bagging Coins and
Weighing
9874 - 5¢ Bags, Bagging Coins and
Weighing
9875 - 1¢ Boxing Coin Bags and Banding
Boxes
9876 - 5¢ Boxing Coin Bags and Banding
Boxes
9877 - 1¢ Boxes (Purchased)
9878 - 5¢ Boxes (Purchased)

Mechanical

Dept.

6000

Charge

8273 - 1¢ Die Sets
8274 - 5¢ Die Sets
8673 - 1¢ Grinding Dies
8674 - 5¢ Grinding Dies

Assay

Dept.

3500

Charge

8273 - 1¢
8274 - 5¢

UNITED STATES GOVERNMENT

Memorandum

Panama

TO : Superintendent of Melting, Coining, Assay,
and Mechanical Divisions

DATE: October 4, 1971

FROM : Cost Accounting Branch

SUBJECT: Job Number Panama 5 Balboa Blanks

Melting

<u>Dept.</u>	<u>Charge</u>	<u>Denomination</u>
7700	7761	Ingot

Process-Weighing

8100	8161
------	------

Rolling (Includes Slab Annealing)

7900	7961
------	------

Blanking

8200	8261
------	------

Counting

Stores	Items	8700	8761
	Bags	8700	8761
	Boxes		8762

Assay

3500	7761 Ingot
------	------------

Mechanical

6000	8261 5 Balboa Die Sets
	8561 5 Balboa Discs & Segments



OFFICE OF
DIRECTOR OF THE MINT

THE DEPARTMENT OF THE TREASURY

WASHINGTON, D.C. 20220

JUN 8 - 1972

OFFICE OF
SUPERINTENDENT

U. S. MINT AT DENVER

June 6, 1972

✓ Superintendent, U. S. Mint, Denver, Colorado
Officer in Charge, U. S. Assay Office, San Francisco, California

The Government of Panama has approved the 5 Balboa FAO trial strikes.

The Denver Mint is requested to proceed with the manufacturing of the necessary tooling and the rolling of sufficient 900 Ag-100 Cu billets to furnish San Francisco with 500 cut blanks, for experimental purposes, having the following specifications:

Diameter: 1.517" + .003
- .000
Thickness: .114" + .0015
- .000

Stamps only

By copy of this letter, the Philadelphia Mint is authorized to ship to San Francisco ten (10) pairs of 5 Balboa dies and 6 collars. The dies should not be polished.

Upon receipt of the foregoing items, the San Francisco Assay Office is to proceed with the testing of the upsetting segment which is now ready. When testing has been satisfactorily completed, San Francisco should advise this office of their cut blank requirement for this order. Both the proof and uncirculated coins are to be double-struck. It is proposed that this coinage, 10,000 proof and 70,000 uncirculated coins, be completed and ready for pick-up September 1, 1972. Funds for overtime were not included in our estimate or billing for this order.

Sincerely,

F. H. MacDonald
Acting Director of the Mint

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendents of Melting, Coining, Assay and Mechanical Divisions **DATE:** August 8, 1973

FROM : Cost Accounting Branch

SUBJECT: Job Numbers - Panama 900 Fine Silver, 70,000 Blanks for 1 Balboa

Melting:

<u>Dept.</u>	<u>Charge</u>	<u>Denomination</u>
7700	7785	Ingot

Material Handling:

7800	7885-3	Strip
	7885-4	Scrap
	7885-1	Preparation of Shipment

Process Weigh:

8100	8185	1 Balboa
------	------	----------

Rolling:

7900	7985	1 Balboa
------	------	----------

Blanking:

8200	8285	1 Balboa
------	------	----------

Counting:

8700	8785	1 Balboa
------	------	----------

Assay:

3500	7785	Ingot
------	------	-------

Mechanical:

6000	8285	Die Sets - 1 Balboa
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Notes on Panamanian Currency

ALDORE FIVE
PANAMA COMPANY

